

Date: Tuesday, 22/04/2008 10:34:31 AM  
User: Julie Lecocq

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY LH
Job Number	: 38729		
Estimate Number	: 10266		
P.O. Number	:	Part Number	: D350636013
This Issue	: 22/04/2008 S.O. No. :	Drawing Number	: D2750 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: E
Previous Run	: 38728	Material	:
	Type : LANDING GEAR	Due Date	: 15/05/2008
Written By	:	Qty:	1 Um: Each
Checked & Approved By	: <u>JLD 08.4.22</u>		
Comment	: Est Rev:H 02.09.25 Rearranged procedure steps KJ est rev I 06.03.30 Per rev. D dwg EC Est Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL JLD 08.4.23 CH2004  
Photocopy blue file and type labels per PPP D350-636-013 CHG 003



2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

039413

1

W

8-4-29

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B37768

BE 08/05/01

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8864 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

232208-5-1



NO. 153

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 38543  
Part number: D350 636 011  
Description: 2nd tube 350  
Welding Process: Tig[ ☒ ] Mig[ ☐ ]  
Base material: Aluminium  
Current: AC[ ☒ ] DC[ ☐ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[ ☒ ] fail[ ☐ ]  
pass[ ☒ ] fail[ ☐ ]

UNACCEPTABLE

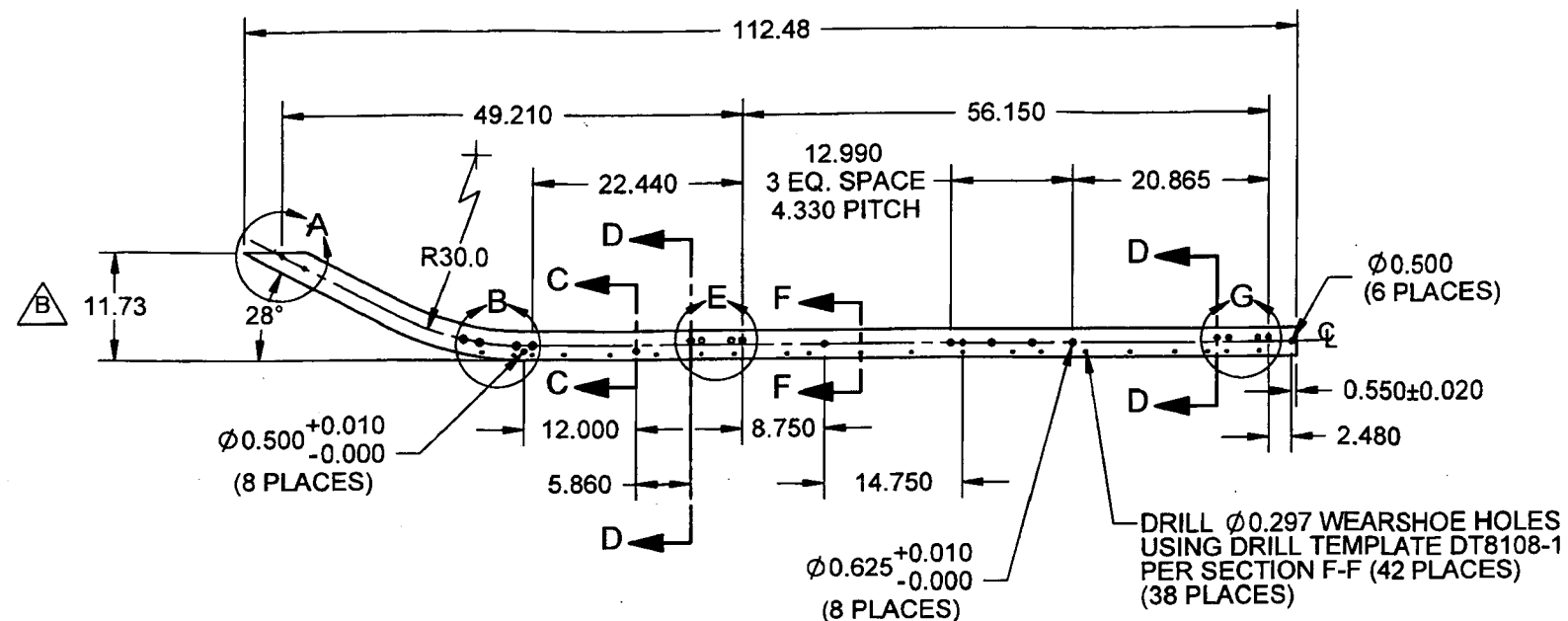
Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[ ☒ ] fail[ ☐ ]  
pass[ ☒ ] fail[ ☐ ]  
pass[ ☒ ] fail[ ☐ ]  
pass[ ☒ ] fail[ ☐ ]  
pass[ ☒ ] fail[ ☐ ]  
pass[ ☒ ] fail[ ☐ ]

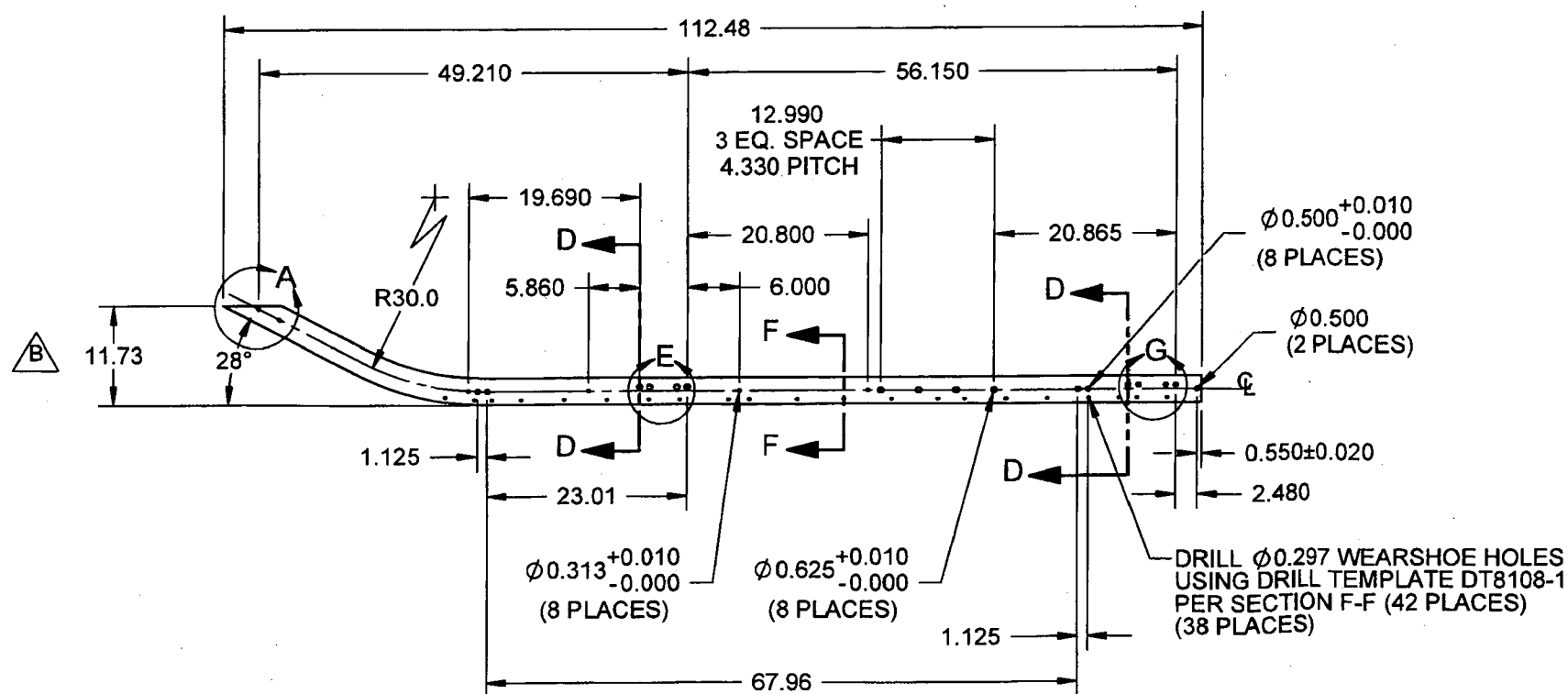
Qualifier Det Duval Date of Test Coupon 08-05-07

Welder Det Barclay Elliot Date of Test Coupon 08-05-07

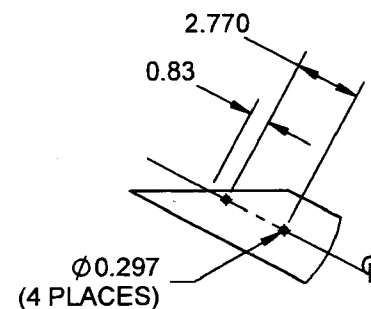
The above named individual is qualified in accordance with AWS D17.1.2001 to weld



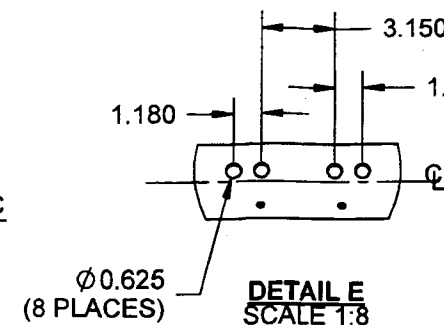
**D2750-1 LH SKIDTUBE (SHOWN)**  
**D2750-2 RH SKIDTUBE (OPPOSITE)**



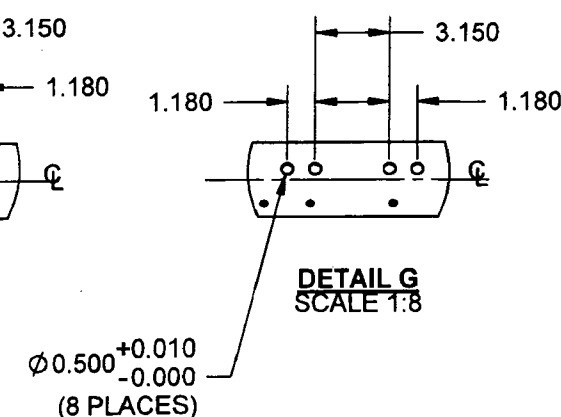
**D2750-3 LH SKIDTUBE (SHOWN)**  
**D2750-4 RH SKIDTUBE (OPPOSITE)**



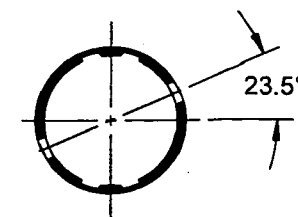
**DETAIL A**  
SCALE 1:8



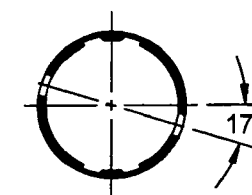
**DETAIL E**  
SCALE 1:8



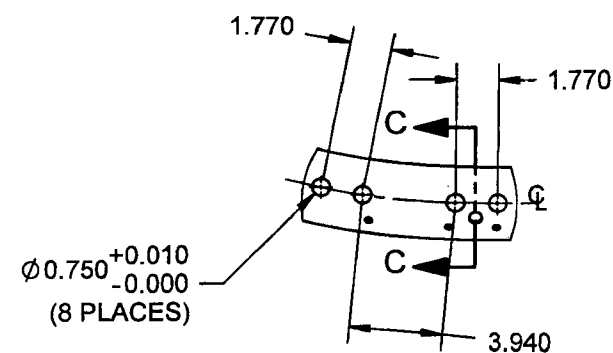
**DETAIL G**  
SCALE 1:8



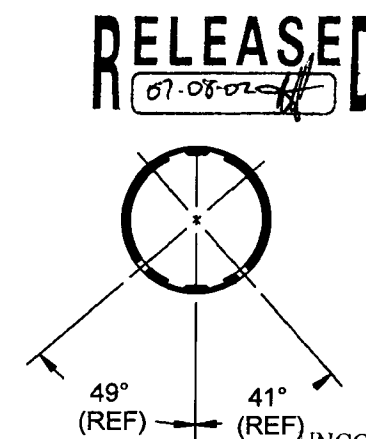
**SECTION C-C**  
SCALE 1:4



**SECTION D-D**  
SCALE 1:4



**DETAIL B**  
SCALE 1:8  
(ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)



**SECTION F-F**  
SCALE 1:4

**RELEASED**  
07-08-02

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WORK ORDER  
NO. 38729

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2750	REV. E SHEET 3 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20
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